

# Work Order ID 69143

Tuesday, May 03, 2011 10:54:44 AM



Page 1

Item ID:	D3914-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Lid Assembly (350)					
Start Date:	5/3/2011	Start Qty:	1.00		Cust Item ID:	Ship May 18th
Required Date:	5/9/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-05-3	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3914	B

100	Weld per dwg A/R S.S. rod Batch: 115928	0.00							
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	Large Fab								
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Large Fab	Memo	0.00							
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	1- assemble ribs , weld as per dwg D3914 using DT9607A								
	2- weld hinge (3) and Mounting brackets as per dwg D3914								
	***inspect before welding mesh***								
	3- tack weld mesh on basket as per dwg D3914								
	***make sure to place mesh correctly on lid, check with label plate before tacking mesh***								

110	QC9- Inspect visual per QS1004- Fusion Welds	0.00							
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QC	Memo	0.00							
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Quality Control									
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BE  
11.05.13

11.05.12

1 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69143**

Tuesday, May 03, 2011 10:54:45 AM



Page 2

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

S. Miller 1/3

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

\*\*\* mask sides of hinge prior to powdercoat\*\*\*

Start Time:

Oven Temperature:

Finish Time:

3:45 320 °F  
4:15

140

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

\*\*\*Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label \*\*\*

IX ~~Ø~~ M-L 4/05/13IX ~~Ø~~ M-L 4/05/16

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Page 3

Item ID: D3914-041

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Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 BR 11-5-16

160

Identify as per dwg &amp; Stock Location GA

0.00



Packaging

Memo

w/o 69135

0.00

Packaging

ES 11/05/16 @

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/16 J  
11-05-16-1

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 10:54:51 AM

Page 1

Work Order ID: 69143

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)



Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev:A new issue DD 10.03.19 verified by:EC  
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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✓



Mounting Bracket

Manufactured

No

100

Each

12.0000

2

2



Pl 11.05.12

### Location

WA005

### Loc Qty

12

### Loc Code

B68964 → (2)

66806

12

✓



Rib

Manufactured

No

100

Each

0.0000

2

2



B69087 → (2) Pl 11.05.12

✓



Rib

Manufactured

No

100

Each

6.0000

2

2



~~B69087 → 2~~

### Location

WA

### Loc Qty

1

### Loc Code

66620

1

WA006

5

66980

1

68175

4

(2)

Pl 11.05.12

✓



Hinge Half, Lid

Manufactured

No

100

Each

6.0000

3

3



Pl 11.05.12

### Location

WA005

### Loc Qty

6

### Loc Code

67040

6

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Tuesday, May 03, 2011 10:54:51 AM

Work Order ID: 69143



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

D4035-043

Manufactured No

100

Each

7.0000

1

1



Lid Rib Assembly, Aft (350 Basket)



*CP 11.05.12*

Location

Loc Qty

Loc Code

WA006

7

67336

1

67375

6

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label



*①*

*9/5/05/16*

*9/5/05/16*



*D4086-200*

*B# 66276*

*(1K)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

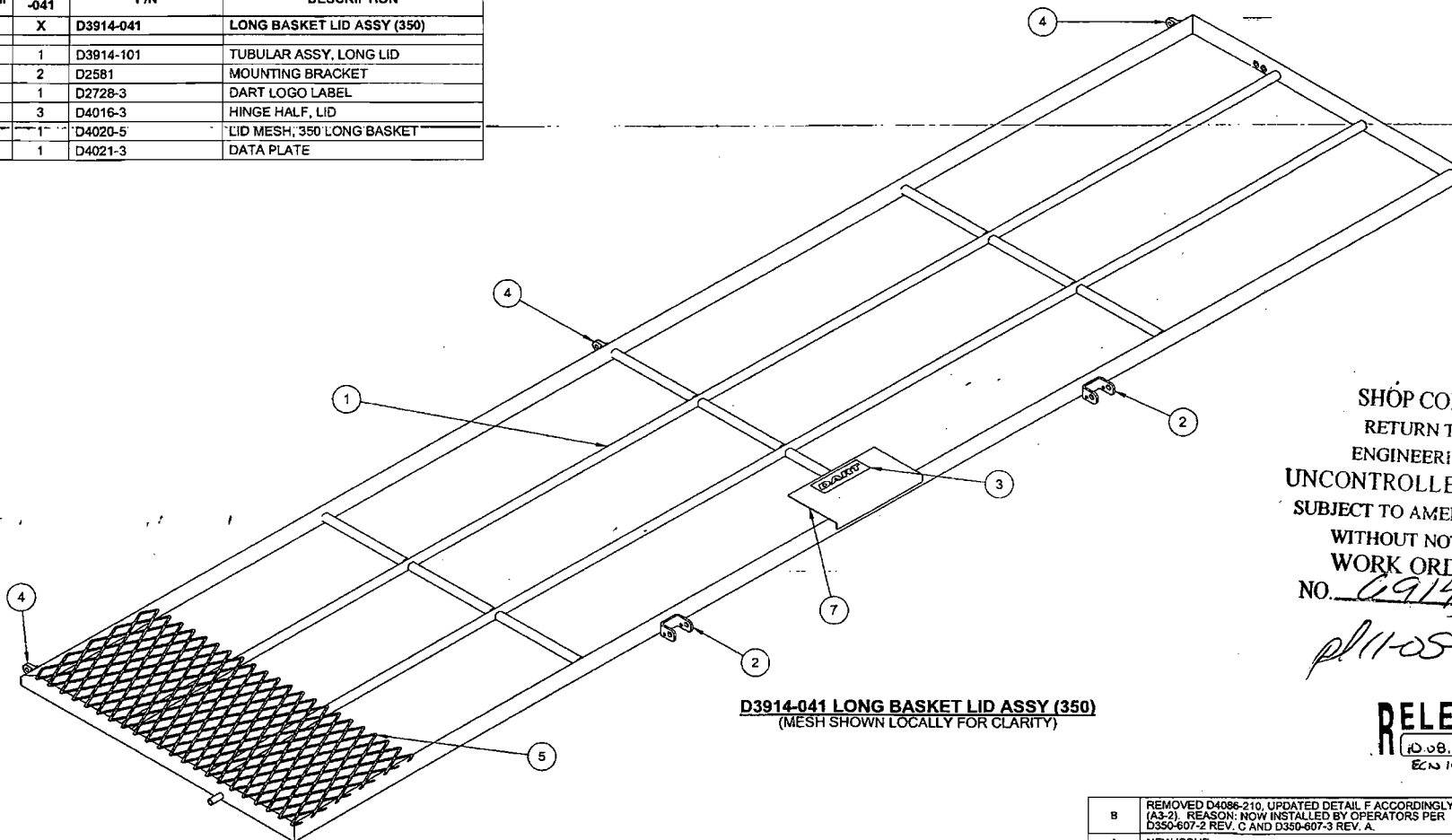
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 09143

*PH11-05-3*

**RELEASED**  
10.08.17  
ECN 10-546

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. <b>D3914</b> REV. B SHEET 1 OF 4  <b>LONG BASKET LID ASSY (350)</b> NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	MS		
DE APPR.	MS		
DATE	10.08.05		

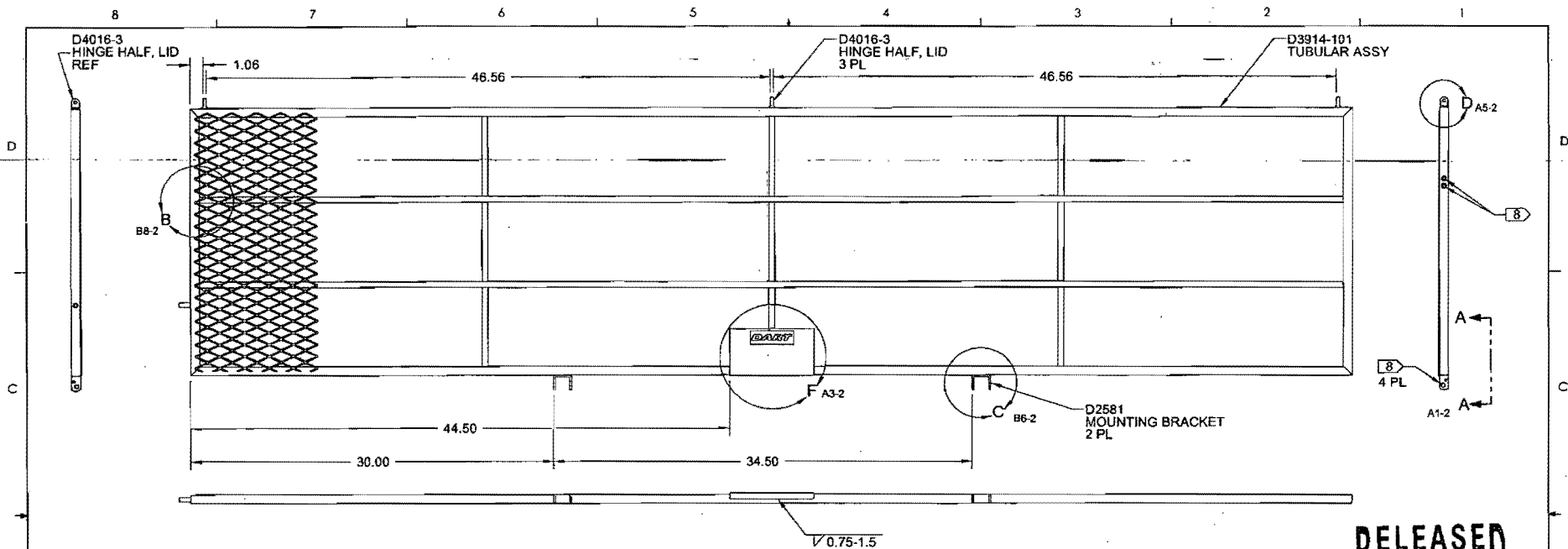
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

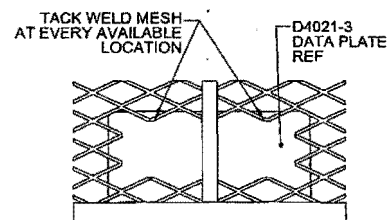
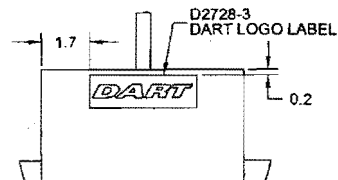
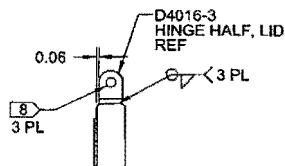
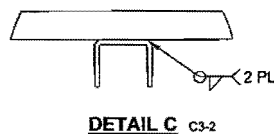
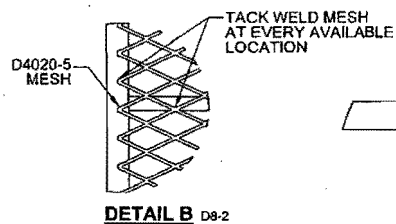
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**NOTE:** Date & initial all entries



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)



- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 22.35 lbs APPROX
  - 8) MASK HOLES PRIOR TO FINISHING
  - 9) WELD PER DART QSI 004

*w/loc 1143*

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 2 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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**RELEASED**  
10.08.12 UP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

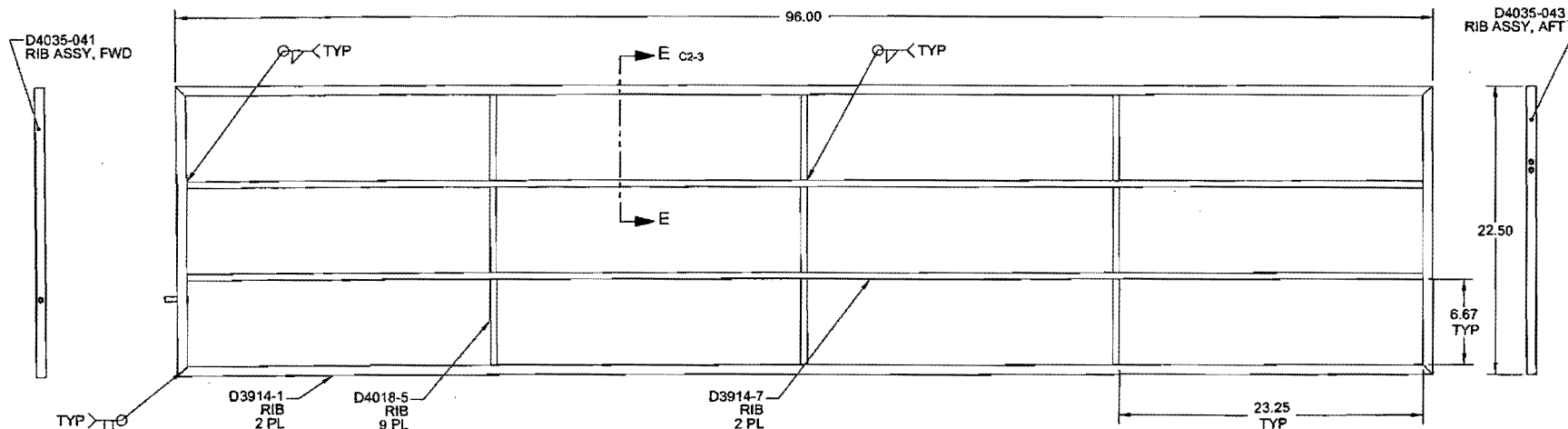
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



RELEASED  
10.08.05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

D3914-101 TUBULAR ASSY, LONG LID

DESIGN	ALS	DART AEROSPACE LTD	REV. B
DRAWN	RC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MD	DRAWING NO. D3914	SHEET 3 OF 4
MFG. APPR.	MD	TITLE LONG BASKET LID ASSY (350)	SCALE NTS
APPROVED	MD		
DE APPR.	MD		
DATE	10.08.05		

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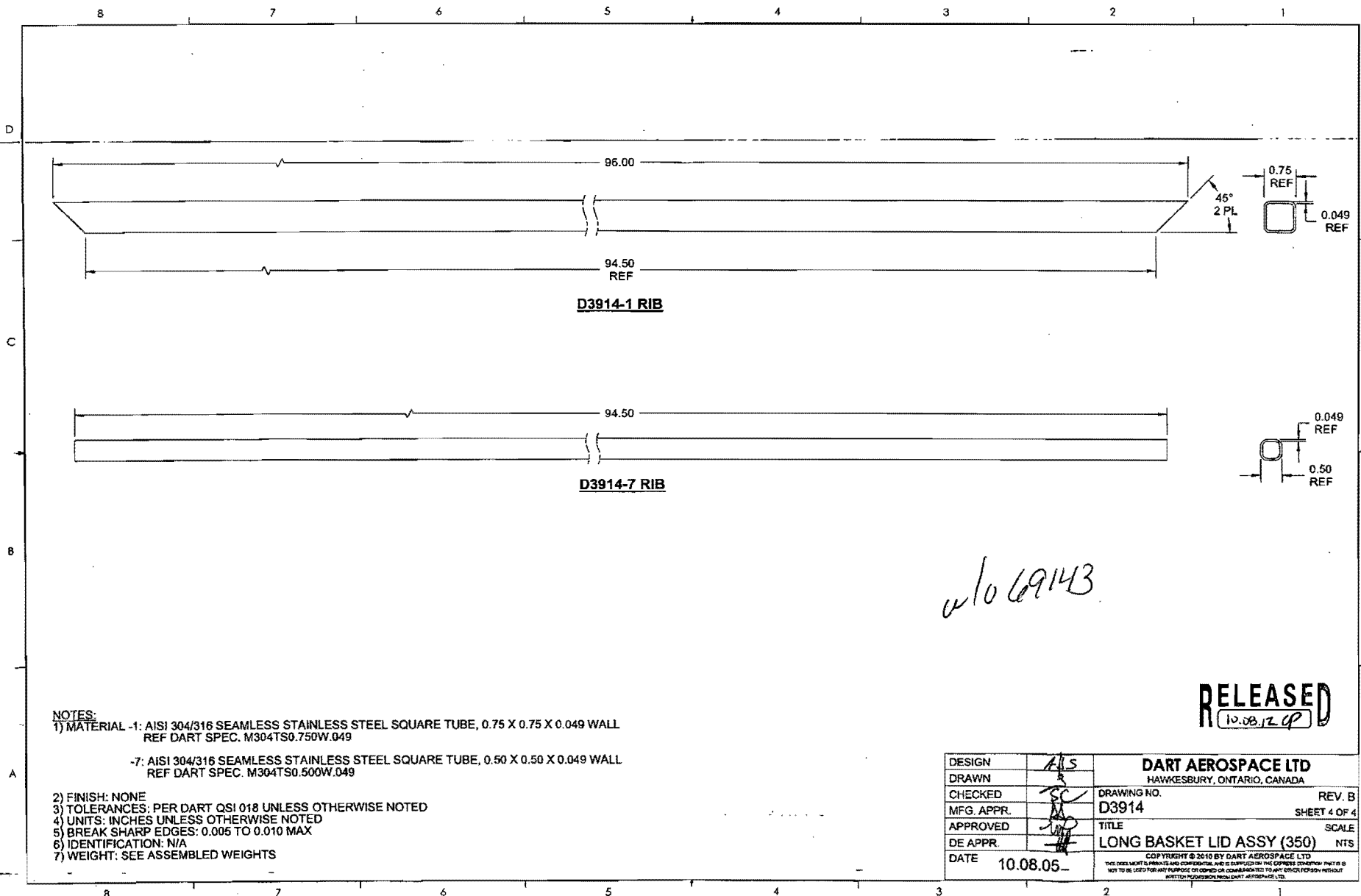
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